

Order 827e



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB AN8514-1-2
Job Sheet 183747



Part No: RB AN8514-1-2

Job Qty: 10 ea 9

Part Name: Wrench Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/25/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB AN8514 Rev 4 IPP Rev A 18.01.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/28/18	0.00	0.00	Start Up Waterjet		OK 18/10/04
100	Waterjet - B4B	10 pcs		9/28/18	0.00	1.00	Waterjet 2 OMAX		OK 18/10/04
110	QC	10 pcs		9/28/18	0.00	0.00	QC2 Waterjet-4		OK 18/10/04
120	Mori Seiki	10 pcs		9/28/18	0.00	10.00	MORI NV5000-2		J.C.V.
130	QC	10 pcs		9/28/18	0.00	0.00	QC2-2		J.C.V. - L. 18-10-12
140	QC	10 pcs		9/28/18	0.00	0.00	QC8		OK 18-10-12
160	Outsource	10 pcs		9/28/18			ATL002-VC	8	OK OCT 23 2018
180	Packaging	10 pcs		9/28/18	0.00	0.00	Packaging2		OK OCT 29 2018
190	QC	10 pcs		9/28/18	0.00	0.00	QC6		OK 38
200	Packaging	10 pcs		9/28/18	0.00	0.00	Packaging3-1		OK 9-88
210	QC21-SA	10 Ea		9/28/18	0.00	0.00	QC21		OK NOV 01 2018

Part Op 100 - 1-Cut as per Dwg (Red Barn folder) Dwg Rev: 4 Prog Rev: 4 2-Deburr if necessary.
Descriptions: 120 - 1-Machine as per folio FC059 FOLIO REV: AA DWG REV: 4 2-Deburr 3-Engrave T/N
And / or S/N number as required Using Marktronic engraver as per DWG.

160 - 1-Issue P/O to ATLANTIC HEAT TREAT; P/O 04417 RC 22-32 2-Bead blast 3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-0.500X4.000	4140 Steel Bar 0.500 X 4.000	1.3000 ft (.13 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-0.500X4.000	1	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART
AEROSPACE

1210 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S115984



Part: RB AN8514-1-2

Job No: 183747

Serial No/Batch: S115984

Revision: 4

Inspector:

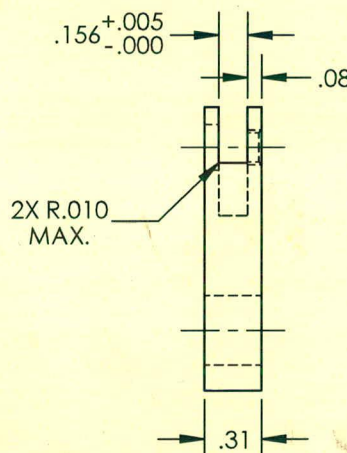
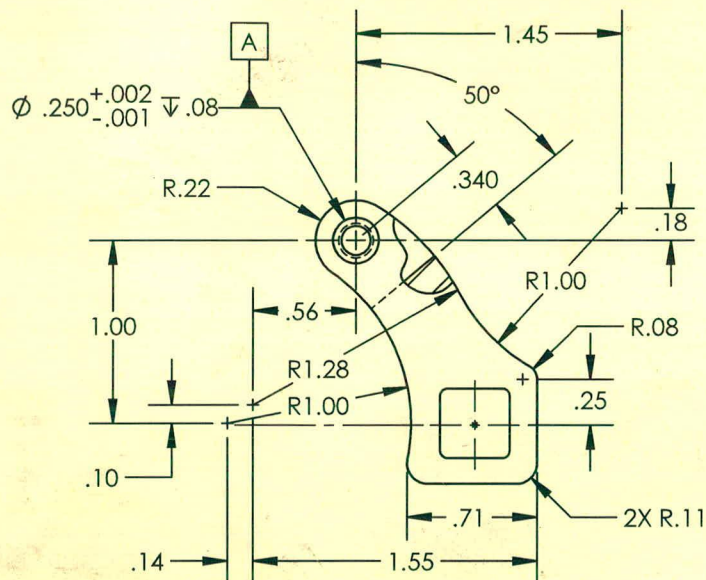
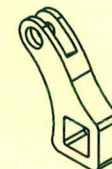
Exp Date:

Instructions:

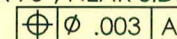
Date: 10/04/18

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
B		CH'D ENGRAVE NOTES.	8/3/2009	RJC	RW
C		-2 ADDED MISSING DIMS, CH'D SOME DIM PRECISION TO MATCH INFO REC'D.	1/10/2011	RJC	SE
4	16-0046	-2 CH'D MAT'L WAS 4140 IS 4140/4142, ADDED MISSING DIM'S 2X R.010 MAX. .14 & .10, .18, CH'D DIMS WAS .384-.379 IS 2X .383-.378. DELETED .024 X 45°.	3/1/2016	RJC	JAG

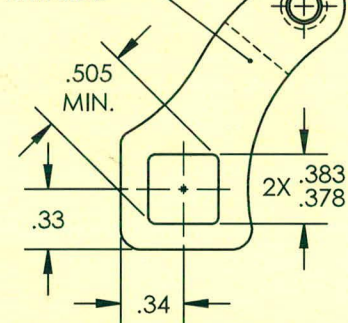
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183747 M



10-32 UNF - 2B ∇ .08
 $\checkmark$ ϕ .19 X 90°, NEAR SIDE



ENGRAVE P/N
THIS SIDE,
ENGRAVE T/N, S/N,
MADE IN USA
FAR SIDE



②
HANDLE



TITLE
ADJUSTABLE SPANNER WRENCH

DWG NO.

RB AN8514-1-2

REV
4

MAT'L 4140/4142

HEAT RC 22-32
TREAT

TREAT FINISH BLACK OXIDE

SPEC	QMSI-6.2.2 REV D
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DRAWN BY:	COLE
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DRAWN BY:	COLE
CHECKED:	DUER

CHECKED.	DUERFE
OPPS APPR:	ANDERSON

OPPS APPR:	ANDERS
CL APPR:	ANDERS

QA APPR:	LINDSAY
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APPROVED:	GILBERT
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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

DIMENSIONS ARE IN INCH
TOLERANCES: FRACTIONS + 1/8

XX $\pm$.005 FRACTIONS $\pm$ 1/8
X $\pm$.01 ANGLES $\pm$ 5°

± .1 ANGLES ±.0
SURFACES =

BREAK ALL SHARP EDGES

015 x 45° OR .015R
DIMENSIONAL LIMITS APPLY

DIMENSIONAL LIMITS APPLY AFTER PLATING

INTERPRET DIM AND TOL PER
ASME Y14.5M-2000

ASME Y14.5M-2009

USED ON MODEL

BELL 212, 230, 407, 412

SCALE	1:1
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DATE	6/26/2000
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SHEET 2 OF 5



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041417**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041417
PO Date: 10/23/18
Due Date: 10/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184993	PC250-750	Link 1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC 42-44 2-Bead blast 3--Material type; O1 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH***	Firmed	-	10/31/18	50 pcs	0 pcs	50 pcs	\$1.65/pcs	\$82.50
2	183747	RB AN8514-1-2	Wrench Handle 1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC 22-32 2-Bead blast 3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	10/31/18	9 pcs	0 pcs	9 pcs	\$22.222222/pcs	\$200.00

9 X OCT 29 2018

DAS
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9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041417**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	183751	RB AN8514- 1-6	Arm, Adjustable Spanner Wrench 1-Issue P/O to ATLANTIC HEAT TREAT ; P/O RC 22-32 2-Bead blast 3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	10/31/18	10 pcs	0 pcs	10 pcs	\$20.00/pcs	\$200.00
Grand Total:											\$482.50

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 10/29/18 8:03 AM dart.tsimiklis.chrisoula

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 156810
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041417 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
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✓ 9PCS

SAND BLAST AND BLACK OXIDE

C OF C, PRT# RB AN8514-1-2, JOB# 183747 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 9

Pounds Shipped: 1.00

Order No.: 159681

Shipped Complete

Quantity Shipped: 9.00

Received By:

Date:

Pounds Shipped: 1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 10/24/2018

AK
31 Re
B.O
10-25-18

Shipping Ticket

Form No. 1005
Rev. 1-1-74

SHIPMENT NO. 1005
DATE OF SHIPMENT 1-1-74

SHIPMENT NO. 1005
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DATE OF SHIPMENT 1-1-74

SHIPMENT NO. 1005
DATE OF SHIPMENT 1-1-74

Certification

Date: 10/24/2018

Entry Date: 10/24/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041417

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: BLACK OXIDE

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
9	9PCS SAND BLAST AND BLACK OXIDE C OF C, PRT# RB AN8514-1-2, JOB# 183747	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

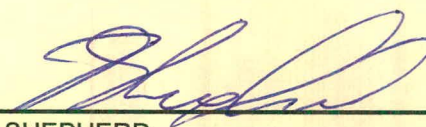
Results:

Harden ROCKWE 22. 32. 31. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 31 RC AS PER CUSTOMER REQUEST

BLACK OXIDE AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

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KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

Continuation

March 1900

Continuation